

Date: Tuesday, 8/21/2007 3:43:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 34187		
Estimate Number	: 12922		
P.O. Number	: N/A	Part Number	: D2655UP
This Issue	: 8/21/2007 S.O. No. : N/A	Drawing Number	: D2655 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>JD 07-08-22</u>	Due Date	: 9/20/2007 Qty: 12 Um: Each
Checked & Approved By	: <u>JD 07-08-22</u>		
Comment	: Est Rev: A New Issue 07-07-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018B400X250	Inventory
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Comment: Qty.: 0.2835 f(s)/Unit Total : 3.4020 f(s)

1018 ASTM A36 .250" thk bar x 4.0"

Batch: M 105358 IB 07-08-24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2655

Dwg Rev: B

Prog Rev: B

IB 07-08-24

2-Deburr if necessary

SAD 07/09/13

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-08-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/09/04

(12)

counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling

SAD 07/09/13

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/09/14









QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Job Number: 34187		Part Number: D2655UP	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	QC5	INSPECT WORK TO CURRENT STEP	
			<i>co-centers</i>
Comment: INSPECT WORK TO CURRENT STEP		<i>En 09/09/13</i> <i>(412)</i>	
7.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Blue</u>		<i>U</i>	<i>A 09.13</i> <i>12</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE	
			<i>(12)</i>
Comment: FINAL INSPECTION/W/O RELEASE		<i>U 09/14</i>	
Job Completion			
		<i>U 09.14</i>	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

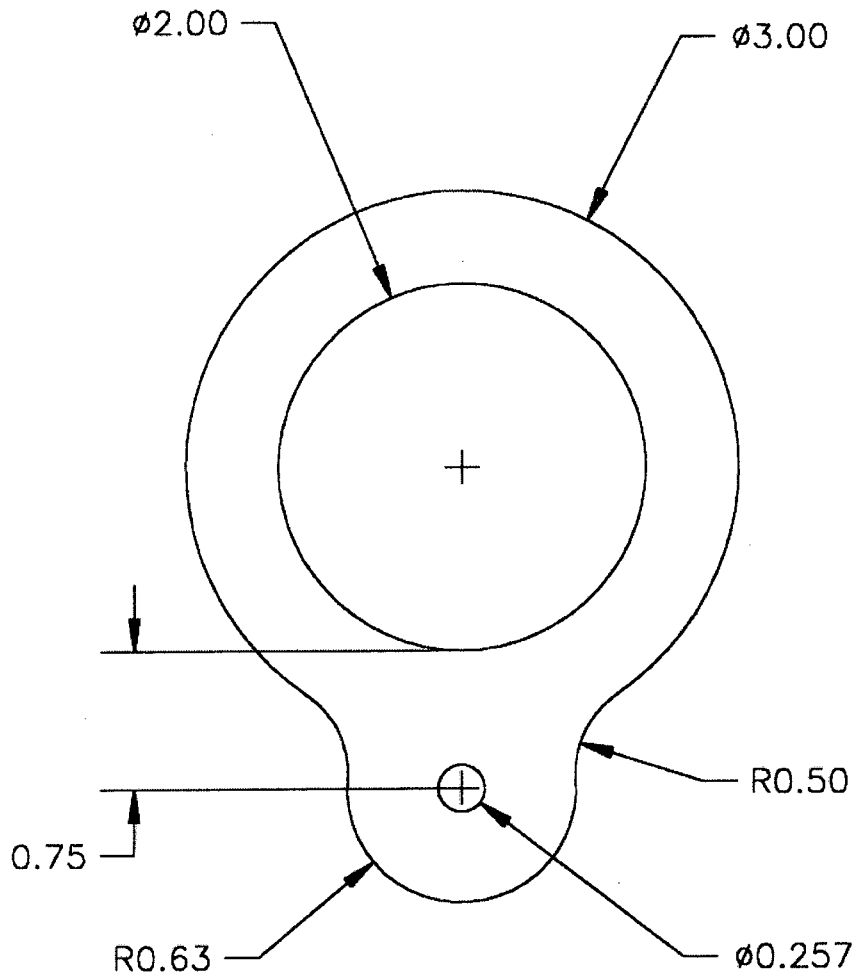
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED
47/07/11 DS



NOTE: DEBURR ALL SHARP EDGES
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34187